

# VERTRAG ÜBER DIE INTERNATIONALE ZUSAMMENARBEIT AUF DEM GEBIET DES PATENTWESENS

Absender: MIT DER INTERNATIONALEN VORLÄUFIGEN PRÜFUNG BEAUFTRAGTE BEHÖRDE

PCT

An:

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AUFFORDERUNG ZUR EINSCHRÄNKUNG DER ANSPRÜCHE ODER ZUR ZAHLUNG ZUSÄTZLICHER GEBÜHREN

(Artikel 34(3)a) und Regel 68.2 PCT)

VORAB PER FAX (05-06-2005)

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10.06.2005

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ANTWORT FÄLLIG

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Internationales Aktenzeichen  
PCT/EP2005/050374

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(Tag/Monat/Jahr)

28.01.2005

Anmelder

KOENIG & BAUER AKTIENGESELLSCHAFT ET AL.

- Die mit der internationalen vorläufigen Prüfung beauftragte Behörde
  - ist der Auffassung, dass die internationale Anmeldung dem Erfordernis der Einheitlichkeit der Erfindung aus den im Anhang angegebenen Gründen nicht genügt (Regel 13.1, 13.2 und 13.3).
  - ist der Auffassung, dass mit der internationalen Anmeldung 2 Erfindungen beansprucht werden (siehe Anhang).
  - weist darauf hin, dass sich die internationale vorläufige Prüfung nicht auf Ansprüche erstrecken muss, die sich auf Erfindungen beziehen, für die kein internationaler Recherchenbericht erstellt worden ist (Regel 66.1 e)).
- Der Anmelder wird daher aufgefordert, die Ansprüche innerhalb der oben genannten Frist einzuschränken, wie unter Punkt 3 unten vorgeschlagen, oder den nachstehend angegebenen Betrag zu bezahlen:
 

EUR 1530,00	x	1	=	EUR 1530,00
Gebühr pro zusätzliche Erfindung		Zahl der zusätzlichen Erfindungen		Gesamtbetrag der zusätzlichen Gebühren

Der Anmelder wird draufhingewiesen, dass gemäss Regel 68.3 c) die Zahlung zusätzlicher Gebühren unter Widerspruch erfolgen kann; dem Widerspruch ist eine Begründung des Inhalts beizufügen, dass die internationale Anmeldung das Erfordernis der Einheitlichkeit der Erfindung erfülle oder dass der Betrag der geforderten zusätzlichen Gebühr überhöht sei.
- Falls sich der Anmelder für eine Einschränkung der Ansprüche entscheidet, schlägt die Behörde die im Anhang angegebenen Einschränkungsmöglichkeiten vor, die nach ihrer Auffassung dem Erfordernis der Einheitlichkeit der Erfindung genügen.
- Geht keine Erwiderung des Anmelders ein, so erstellt die Behörde den internationalen vorläufigen Prüfungsbericht über die im Anhang angegebenen Teile der internationalen Anmeldung, die sich nach ihrer Auffassung auf die Haupterfindung zu beziehen scheinen:

Name und Postanschrift der mit der internationalen Prüfung beauftragten Behörde



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**AUFFORDERUNG ZUR EINSCHRÄNKUNG  
DER ANSPRÜCHE ODER ZUR ZAHLUNG  
ZUSÄTZLICHER GEBÜHREN**

Internationales Aktenzeichen PCT/EP2005/050374

**Zu Punkt IV**

Die in den mit dem Brief vom 18. April 2005 eingereichten Ansprüchen enthalten verschiedenen Erfindungen sind:

Ansprüche 1-18, 20-65:

Eine Druckmaschine mit einem Falzapparat in Modulbauweise.

Ansprüche 19, 31-38, 41-60:

Eine Druckmaschine mit einem Falzapparat, mit einem ferngesteuerten veränderbaren Abstand zwischen Haltesystemen und zugehörigen Falzmessern.

Aus den folgenden Gründen hängen diese Erfindungen nicht so zusammen, daß sie eine einzige allgemeine erfinderische Idee verwirklichen (Regel 13.1 PCT):

Dokument EP-A-0956973 (D1) wird als nächstliegender Stand der Technik angesehen.  
Die Unterschiede zwischen den zwei Erfindungen und D1 sind die folgenden:

Ansprüche 1-18, 20-65:

D1 offenbart (die Verweise in Klammern beziehen sich auf dieses Dokument) eine Druckmaschine (§[0001]) mit zumindest einer Druckeinheit (1), auf der eine Bedruckstoffbahn (2) im Offsetdruck mit variabler Abschnittslänge (§[0006]) bedruckbar ist, wobei der Druckeinheit (1) zumindest ein Falzapparat mittelbar oder unmittelbar angeordnet ist, dessen Abschnittslänge veränderbar ist (Spalte 3 Zeilen 13-16).

Die Unterschiede zwischen dem vorliegenden unabhängigen Anspruch 1 und D1 sind die folgenden:

- (a) die Montage von einem auswechselbaren Modul in dem Gestell;
- (b) der separate Antrieb von den Zylindern des Falzapparates;
- (c) der veränderbare Abstand zwischen den mindestens drei Haltesystemen und den zugehörigen Falzmessern im Falzapparat.

Zu (b): Es handelt sich hierbei um eine bekannte übliche konstruktive Gestaltung.

Zu (c): Aus D1 gibt es dem Fachmann einen Hinweis, eine solche Abstandsveränderung zwischen Haltesysteme und Falzmesser aus dem Dokument EP-A-0257390 (D2) zu entnehmen, und mit dem Falzapparat vom D1 zu kombinieren.

Der einzige Unterschied, der in Kombination mit den anderen Merkmale eine erfinderische

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Tätigkeit aufweisen könnte, ist also (a), die Montage von einem auswechselbaren Modul in dem Gestell.

Das zu lösende Problem besteht darin, wie die Auswahl von Formatmöglichkeiten in einer Druckmaschine zu erhöhen.

Ansprüche 19, 31-38, 41-60:

D1 offenbart (die Verweise in Klammern beziehen sich auf dieses Dokument) eine Druckmaschine (§[0001]) mit zumindest einer Druckeinheit (1), auf der eine Bedruckstoffbahn (2) im Offsetdruck mit variabler Abschnittslänge (§[0006]) bedruckbar ist, wobei der Druckeinheit (1) zumindest ein Falzapparat mittelbar oder unmittelbar angeordnet ist, dessen Abschnittslänge veränderbar ist (Spalte 3 Zeilen 13-16).

Die Unterschiede zwischen dem vorliegenden unabhängigen Anspruch 1 und D1 sind die folgenden:

- (a) der separate Antrieb von den Zylindern des Falzapparates;
- (b) der veränderbare Abstand zwischen den mindestens drei Haltesystemen und den zugehörigen Falzmessern im Falzapparat.
- (c) der mittels einer Fernsteuerung und vom Durchmesser eines Formzylinders und/oder eines Übertragungszylinders abhängig veränderbare Abstand.

Zu (a): Es handelt sich hierbei um eine bekannte übliche konstruktive Gestaltung.

Zu (b): Aus D1 gibt es dem Fachmann einen Hinweis, eine solche Abstandsveränderung zwischen Haltesysteme und Falzmesser aus dem Dokument EP-A-0257390 (D2) zu entnehmen, und mit dem Falzapparat vom D1 zu kombinieren.

Der einzige Unterschied, der in Kombination mit den anderen Merkmale eine erfinderische Tätigkeit aufweisen könnte, ist also (c), der mittels einer Fernsteuerung und vom Durchmesser eines Formzylinders und/oder eines Übertragungszylinders abhängig veränderbare Abstand. Das zu lösende Problem besteht darin, wie ein Falzapparat so zu steuern, daß die Abschnittslängenbestimmung automatisch erfolgt.

Weil die speziellen technischen Merkmale weder gleich noch verbunden sind (Regel 13.1 und 13.2 PCT), sind die verschiedenen Erfindungen nicht verbunden. Desweiteren ist die vorliegende Anmeldung nicht einheitlich.

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Translation of the pertinent portions of a Notification Regarding the Forwarding of the International Preliminary Report Regarding Patentability, mailed 07/11/2005

2. This REPORT comprises a total of [number missing] pages, including the cover page.

3. Furthermore, this report contains ATTACHMENTS, these comprise:

a. (sent to Applicant and the International Office) a total of 11 pages, these are:

x pages containing the specification, claims and/or drawings which have been changed and on which this report is based, and/or pages with corrections which the Office has approved (see Rule 70.16 and Section 607 of the Administrative Regulations).

4. This report contains information regarding the following items:

Field I Basis of the Report  
Field IV Lack of Unity of the Invention  
Field V Reasoned Determination under Article 35(2)

Field I Basis of the Report

1. Regarding the language, the report is based on the international application in the language in which it was filed, provided nothing different is mentioned under this item.

Regarding the **components** of the international application, the report is based on:

Specification, pages

2 to 13 in the originally filed version,  
1, 1a received 04/25/2005 with letter of 04/18/2005

Claims Nos.

1 to 65 received 04/25/2005 with letter of 04/18/2005

Drawings, sheets

1/23 to 23/23 in the originally filed version.

Field IV Lack of Unity of the Invention

1. Upon the request to limit the claims or to pay additional fees, Applicant has:

X paid additional fees.

3. The Office is of the opinion that the requirement for unity of the invention in accordance with Rules 13.1, 13.2 and 13.3

x has not been met for the following reasons:

see the attached sheet

4. Therefore the report was prepared for the following portions of the international application:

x all portions

Field V Reasoned Determination under Article 35(2)

1. Determination

Novelty	Yes: Claims 1 to 65
	No:

Inventive Activities	Yes: Claims 1 to 65
	No: Claims

Commercial Applicability	Yes: Claims 1 to 65
	No: Claims

2. References and Explanations

see the attached sheet

ATTACHED SHEET

Re.: Item IV:

The different inventions contained in the claims filed with the letter of April 18, 2005, are:

Claims 1 to 18, 20 to 65:

A printing press with a folding apparatus in modular construction.

Claims 19, 31 to 38, 41 to 60:

A printing press with a folding apparatus with a remote-controlled changeable distance between holding systems and associated folding blades.

These inventions are not connected so that they realize a single common inventive idea for the following reasons (Rule 13.1 PCT):

Document EP-A-0 956 973 (D1) is considered to be the closest prior art. The difference between the two inventions and D1 are the following:

Claims 1 to 18, 20 to 65:

D1 discloses (the references in parentheses relate to this document) a printing press (paragraph [0001]) with a least one printing unit (1), on which a web (2) of material to be imprinted can be printed at variable section lengths (paragraph [0006]) by means of offset printing, wherein at least one folding apparatus, whose section length can be changed (column 3, lines 13 to 16), is indirectly or directly assigned to the printing unit (1).

The differences between instant independent claim 1 and D1 are the following:

- (a) mounting an interchangeable module in the frame,
- (b) separate driving of the cylinders of the folding apparatus,
- (c) changeable distance between the at least three holding systems and the associate folding blades in the folding apparatus.

Re (b): this is a known customary constructive design,

Re (c): D1 offers one skilled in the art a suggestion for taking such a change of distance from document EP-A-0 257 390 (D2) and to combine it with the folding apparatus from D1.

Thus, the only difference which in combination with the other characteristics could show a inventive activities is (a), the mounting an interchangeable module in the frame.

The problem to be solved consists in how to increase the selection of format options in a printing press.

Claims 19, 31 to 38, 41 to 60:

D1 discloses (the references in parentheses relate to this document) a printing press (paragraph [0001]) with a least one printing unit (1), on which a web (2) of material to be imprinted can be printed at variable section lengths (paragraph [0006]) by means of offset printing, wherein at least one folding apparatus, whose section length can be changed (column 3, lines 13 to 16), is indirectly or directly assigned to the printing unit (1).

The differences between instant independent claim 1 [sic] and D1 are the following:

- (a) the separate driving of cylinders of the folding apparatus,
- (b) changeable distance between the at least three holding systems and the associate folding blades in the folding apparatus,
- (c) the distance which can be changed by means of remote control as a function of the diameter of a forme cylinder and/or a transfer cylinder.

Re (a): this is a known customary constructive design,

Re (b): D1 offers one skilled in the art a suggestion for taking such a change of distance from document EP-A-0 257 390 (D2) and to combine it with the folding apparatus from D1.

Thus, the only difference which in combination with the other characteristics could show a inventive activities is (c), the distance which can be changed by means of remote control as a function of the diameter of a forme cylinder and/or a transfer cylinder.

The problem to be solved consists in how to control a folding apparatus in such a way that the determination of section lengths takes place automatically.

Since the special characteristics are neither equivalent nor connected (Rule 13.1 and 13.2 PCT), the different inventions are not connected. Furthermore, the present application is not uniform.

Re.: Item V:

Reference is made to the following documents:

D1 EP-A-0 956 973  
D2 EP-A-0 257 390

### 1. Claim 1

1.1 Document D1 which is considered to be the closest prior art discloses (the references in parentheses relate to this document) in accordance with the wording of independent claim 1, a printing press (paragraph [0001]) with a least one printing unit (1), on which a web (2) of material to be imprinted can be printed with variable section lengths (paragraph [0006]) by means of offset printing, wherein at least one folding apparatus, whose section length can be changed (column 3, lines 13 to 16), is indirectly or directly assigned to the printing unit (1).

1.2 The differences between instant independent claim 1 and D1 are the following:

- (a) mounting an interchangeable module in the frame,
- (b) separate driving of the cylinders of the folding apparatus,
- (c) changeable distance between the at least three holding systems and the associate folding blades in the folding apparatus.

Instant claim 1 is therefore novel (Article 33(2) PCT).

1.3 The problem to be solved consists in how to increase the selection of format options in a printing press.

1.4 Although a modular construction of a press is known per se, although a change of the distance between the holding system and the folding blade can be taken from EP-A-0 257 390 (D2), although a separate drive mechanism is also available from the prior art, such a combination is not known in connection with a folding apparatus whose section length is changeable. Such a construction is technically elaborate.

Therefore one skilled in the art would not combine these characteristics in a simple manner for solving the above mentioned problem.

Therefore the instant independent claim 1 shows inventive activities (Article 33(3) PCT).

## **2. Claim 19**

2.1 Document D1 discloses (the references in parentheses relate to this document) in accordance with independent claim 19, a printing press (paragraph [0001]) with a least one printing unit (1), on which a web (2) of material to be imprinted can be printed with variable section lengths (paragraph [0006]) by means of offset printing, wherein at least one folding apparatus, whose section length can be changed (column 3, lines 13 to 16), is indirectly or directly assigned to the printing unit (1).

2.2 The differences between instant independent claim 1 [sic] and D1 are the following:

- (a) the separate driving of cylinders of the folding apparatus,
- (b) changeable distance between the at least three holding systems and the associate folding blades in the folding apparatus,
- (c) the distance which can be changed by means of remote control as a function of the diameter of a forme cylinder and/or a transfer cylinder.

2.3 The problem to be solved consists in how to control a folding apparatus in such a way that the determination of section lengths takes place automatically.

2.4 Although a separate drive mechanism is known per se, although a change of the distance between the holding system and the folding blade can be taken from EP-A-0 257 390 (D2), their combination with a distance which can be changed by means of remote control and is a function of the diameter of a forme cylinder and/or a transfer cylinder is not contained in the prior art.

Therefore one skilled in the art would not combine these characteristics in a simple manner for solving the above mentioned problem.

The instant independent claim 19 therefore shows inventive activities (Article 33(3) PCT).

## **3. Dependent claims 2 to 18, 20 to 65**

By being dependent (directly or indirectly) from new and inventive claims, claims 2 to 18 and 20 to 65 are also new and inventive (Article 33(2) and (3) PCT).

## Specification

The invention relates to a printing press with at least one printing unit for imprinting a web of material to be imprinted by offset printing at a variable section length in accordance with the preamble of claim 1 or 19.

These printing installations can be operated for offset printing and allow printing of variable section lengths in order to increase in this way variability in respect to the printed products to be manufactured.

EP 0 956 973 A2 describes a printing press with at least one printing unit, by means of which a material to be imprinted of variable section length can be printed. In the course of this a folding apparatus for variable section lengths can be employed.

EP 0 257 390 A and WO 03/070612 A1 disclose folding apparatuses for variable formats.

USP 5,060,569, EP 308 942 A2 and EP 315 917 A2 show printing units which have interchangeable modules.

The object of the invention is based on creating a printing press with at least one printing unit for imprinting a material to be imprinted by means of offset printing with variable section lengths.

In accordance with the invention, this object is attained by means of the characteristics of claim 1 and 19.

An advantage of the printing installation in accordance with the invention lies in particular in that a folding apparatus,

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which permits folding at a variable section length, is indirectly or directly arranged downstream of the printing unit. It is possible in this way to match the fold section length to the printed section length, by means of which a highly efficient production of printed products is made possible.

Exemplary embodiments of the invention are represented in the drawings and will be described in greater detail in what follows.

Shown are in:

## Claims

1. A printing press (01) with a least one printing unit (09), on which a web (06) of material to be imprinted can be printed at variable section lengths by means of offset printing, wherein at least one folding apparatus (21), whose section length can be changed, is indirectly or directly assigned to the printing unit (09), characterized in that a frame (23) is provided on the printing unit (09), on which interchangeable modules (24) can be fastened, wherein at least one forme cylinder (26) and/or at least one transfer cylinder (27) of different diameter is seated in different modules (24), that at least its own drive mechanism (47) for the rotatory driving of at least one cylinder of the folding apparatus (21) independently of the printing unit (09), is provided in the folding apparatus, at least one positionally-regulated electric motor (47) is provided as the drive mechanism (47), that the folding apparatus (21) has a folding blade cylinder (44), that the folding blade cylinder (44) has at least three holding systems for gripping signatures and three associated folding blades, and that the distance between the holding systems and the associated folding blades can be changed.

2. The printing press in accordance with claim 1, characterized in that at least one cutting cylinder pair (42) is provided in the folding apparatus (21) which forms a gap through which the web (06) of material to be imprinted can be conducted.

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3. The printing press in accordance with claim 2, characterized in that the cutting cylinder pair (42) is driven at a preset speed independently of the web speed of the web (06) to be imprinted.

4. The printing press in accordance with claim 2 or 3, characterized in that the cutting cylinder pair (42) is driven clocked in accordance with the clock rate of at least one forme cylinder (26) or transfer cylinder (07) in a printing unit (09).

5. The printing press in accordance with one of claims 2 to 4, characterized in that the cutting cylinder pair (42) is driven at a pre-set ratio of numbers of revolution in respect to the number of revolutions of a forme cylinder (26) or transfer cylinder (07) in a printing unit (09).

6. The printing press in accordance with one of claims 1 to 5, characterized in that a collection cylinder (44), which has two multi-armed instrument supports which can be displaced in respect to each other, is provided in the folding apparatus (21).

7. The printing press in accordance with one of claims 1 to 6, characterized in that the folding apparatus (21) has a drive mechanism which is independent of the other functional elements of the printing installation (01).

8. The printing press in accordance with claim 7, characterized in that servo motors (47) which can be regulated are provided in the drive mechanism of the folding apparatus (21) as drive motors.

9. The printing press in accordance with one of claims 1 to 8, characterized in that the cylinder portion and the delivery device of the folding apparatus (21) can be driven independently of each other by means of separate drive motors.

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10. The printing press in accordance with one of claims 1 to 9, characterized in that a folding jaw cylinder (46), which can be provided with springs, is provided in the folding apparatus (21).

11. The printing press in accordance with one of claims 1 to 10, characterized in that a folding blade cylinder is arranged in the folding apparatus (21).

12. The printing press in accordance with one of claims 1 to 10, characterized in that the folding apparatus is embodied as a variable 5:5 system or 7:7 system.

13. The printing press in accordance with one of claims 1 to 12, characterized in that the folding apparatus is embodied in the manner of a cover folding apparatus.

14. The printing press in accordance with one of claims 1 to 13, characterized in that the web (06) to be imprinted is printed by means of a wet offset method in the printing unit (09).

15. The printing press in accordance with one of claims 1 to 13, characterized in that the web (06) to be imprinted is printed by means of a waterless offset method in the printing unit (09).

16. The printing press in accordance with one of claims 1 to 15, characterized in that the printing unit (09) has selectively interchangeable forme cylinders (26), wherein the various forme cylinders (26) respectively have different diameters.

17. The printing press in accordance with one of claims 1 to 16, characterized in that the printing unit (09) has selectively interchangeable transfer cylinders (27), wherein the various transfer cylinders (27) respectively have different diameters.

18. The printing press in accordance with claim 16 or 17, characterized in that the forme cylinders (26) and/or the transfer cylinders (27) have a cylinder circumference of 1156 mm, 1260 mm, 1320 mm and/or 1410 mm.

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19. A printing press with a least one printing unit (09), on which a web (06) of material to be imprinted can be printed at variable section lengths by means of offset printing, wherein at least one folding apparatus (21), whose section length can be changed, is indirectly or directly assigned to the printing unit (09), characterized in that at least its own drive mechanism (47) for the rotatory driving of at least one cylinder of the folding apparatus (21) independently of the printing unit (09), is provided in the folding apparatus, at least one positionally-regulated electric motor (47) is provided as the drive mechanism (47), that a control device is provided, that this control device

sets a distance between the holding system and the folding blade of a folding blade cylinder (44) of the folding apparatus (21) as a function of a diameter of a forme cylinder (26) and/or transfer cylinder (27) by remote control.

20. The printing press in accordance with claim 1, characterized in that the forme cylinders (26) and/or transfer cylinders (27) are adjustably seated in the module (24).

21. The printing press in accordance with claim 1, characterized in that the inking system rollers and/or dampening system rollers are set by means of pneumatic roller locks.

22. The printing press in accordance with one of claims 1, 20 or 21, characterized in that the interchangeable modules (24) are fixed in place in the frame (23) by means of a fitting system.

23. The printing press in accordance with one of claims 1 and 22, characterized in that the interchangeable modules (24) are connected by means of a quick-release system with the air supply and/or the water supply and/or the electrical supply of the frame (23).

24. The printing press in accordance with one of claims 1 or 20 to 23, characterized in that two forme cylinders (26) and two transfer cylinders (27) which form a printing gap are provided in the interchangeable modules (24).

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25. The printing press in accordance with claim 24, characterized in that two forme cylinders (26) and two transfer cylinders (27) and one satellite cylinder are arranged in the modules (24).

26. The printing press in accordance with claim 25, characterized in that a module (24) with or without a satellite cylinder can be selectively inserted into a printing unit.

27. The printing press in accordance with claim 24 or 25, characterized in that a module (24) can be operated as an imprinter for a flying plate change.

28. The printing press in accordance with claim 25, characterized in that two modules (24) can be interchangeably operated as an imprinter for a flying plate change.

29. The printing press in accordance with one of claims 1 or 20 to 24, characterized in that a transport system (30) is provided in the printing installation (01) for transporting a module (24) released from the frame (23) of a printing unit (09).

30. The printing press in accordance with claim 29, characterized in that the transport system (31) is designed as a crane system, in particular in the manner of a gantry crane.

31. The printing press in accordance with one of claims 1 to 30, characterized in that at least one inking system (28) is provided in the printing unit (09).

32. The printing press in accordance with claim 31, characterized in that an inking system (28) has several inking system rollers.

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33. The printing press in accordance with one of claims 1 to 32, characterized in that at least one dampening system (29) is provided in the printing unit (09).

34. The printing press in accordance with claim 33, characterized in that a dampening system (29) has several dampening system rollers.

35. The printing press in accordance with one of claims 1 or 20 to 34, characterized in that the inking systems (28) and/or the dampening systems (29) are arranged outside of the module (24) in the frame (23) of the printing unit (09).

36. The printing press in accordance with one of claims 1 or 20 to 35, characterized in that, for the rotatory driving of the functional elements (28, 29) seated in the frame (23), at least their own drive mechanism, which is independent of the frame (23), is arranged in the frame (23).

37. The printing press in accordance with one of claims 1 or 20 to 36, characterized in that, for driving the functional elements (26, 27) seated in the module (24), their own drive mechanism, which is independent of the frame (23), is provided in the module (24).

38. The printing press in accordance with claim 7, 9, 36 or 37, characterized in that at least one positionally-regulated electric motor (47) is provided as the drive mechanism (47).

39. The printing press in accordance with claim 1, characterized in that the module (24) has its own closed oil chamber.

40. The printing press in accordance with claim 1, characterized in that the frame (23) has a closed oil chamber.

41. The printing press in accordance with one of claims 1 to 40, characterized in that web of material to be imprinted of a width of more than 2000 mm, in particular a width of 2520 mm, can

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be processed in the printing installation (01).

42. The printing press in accordance with one of claims 1 to 41, characterized in that several printing units (09), in particular at least four printing units (09), are provided in the printing installation (01).

43. The printing press in accordance with claim 42, characterized in that a moving web (06) of material to be printed can be imprinted in several printing stages, in particular in several colors, by means of a plurality of printing units (09).

44. The printing press in accordance with one of claims 1 to 43, characterized in that a roll changer (07) is provided in the printing installation (01).

45. The printing press in accordance with claim 44, characterized in that drive belts (33) and/or support straps (32) for supporting the roll (11) of material to be imprinted and seated in the roll changer (07) are provided on the roll changer (07).

46. The printing press in accordance with claim 45, characterized in that the support straps (32) can be driven by means of a drive mechanism.

47. The printing press in accordance with one of claims 1 to 46, characterized in that a conditioning device (08) for conditioning the web (06) to be imprinted, in particular for regulating the web tension and/or for regulating the web edges, is provided in the printing installation (01).

48. The printing press in accordance with one of claims 1 to 47, characterized in that a drying installation (13) is provided in the printing installation (01).

49. The printing press in accordance with claim 48, characterized in that a web (06) of material to be imprinted,

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which had been printed in several stages one after the other in a plurality of printing units (09), can be dried in the drying installation (13).

50. The printing press in accordance with claim 48 or 49, characterized in that a cooling device (14) for cooling the printed web (06) of material to be imprinted is provided in the drying installation (13).

51. The printing press in accordance with one of claims 48 to 50, characterized in that a dampening device (16) for moistening the printed web (06) of material to be imprinted is provided in the drying installation (13).

52. The printing press in accordance with one of claims 1 to 51, characterized in that a draw-in and/or cutting device (18) is provided in the printing installation (01).

53. The printing press in accordance with one of claims 1 to 52, characterized in that a turning device (19) is provided in the printing installation (01).

54. The printing press in accordance with one of claims 1 to 53, characterized in that a former (22) for the longitudinal folding of the web (06) of material to be imprinted is provided in the printing installation (01).

55. The printing press in accordance with claim 54, characterized in that at least one former (22) is equipped with a gluing device for gluing a longitudinal fold.

56. The printing press in accordance with one of claims 1 to 55, characterized in that a superstructure system (34, 36, 37, 38, 39) is provided in the printing installation (01), in particular a superstructure system (34, 36, 37, 38, 39) of asymmetrical, symmetrical or compact construction.

57. The printing press in accordance with claim 57, characterized in that at least one former for longitudinal folding of the web (06) to be imprinted and/or at least one turning bar for changing the direction of the web (06) to be imprinted is provided in the superstructure system (34, 36, 37, 38, 39).

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58. The printing press in accordance with one of claims 1 to 57, characterized in that at least one web interception device is provided in the printing installation (01).

59. The printing press in accordance with one of claims 1 to 58, characterized in that at least one coating installation (17) is provided in the printing installation (01).

60. The printing press in accordance with claim 59, characterized in that the coating installation (17) is suitable for coating the web (06) of material to be imprinted with a silicon layer.

61. The printing press in accordance with claim 1, characterized in that several printing presses, each with several printing units (09), are placed in parallel, and their webs are processed in a common folding apparatus.

62. The printing press in accordance with claim 1, characterized in that the holding systems are embodied as gripper systems or spur needle systems.

63. The printing press in accordance with claim 1, characterized in that, in a first operational state with a rubber blanket applied, the transfer cylinder (27) has a first diameter and, in a second operational state with the rubber blanket applied, has a second diameter, wherein the first and second diameters differ by at least 5 mm.

64. The printing press in accordance with claim 1, characterized in that, in a first operational state with a rubber blanket applied, the transfer cylinder (27) has a first diameter and, in a second operational state with the rubber blanket applied, has a second diameter, wherein the first and second diameters differ by at least 10 mm.

65. The printing press in accordance with claim 1, characterized in that a control device is provided, that this control device sets a distance between the holding system and the

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folding blade of a folding blade cylinder (44) of the folding apparatus (21) as a function of a diameter of a forme cylinder (26) and/or transfer cylinder (27) by remote control.

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